

Work Order ID 164273

Monday, July 17, 2017 8:54:41 AM

164273

Page 1

Item ID: D3537-3 Accept ***N9000040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Wearpad
Start Date: 8/25/2017 Start Qty: 16.00 ***16*** Cust Item ID:
Required Date: 9/6/2017 Req'd Qty: 16.00 ***16*** Customer:
Reference:

Approvals: Process Plan: DAS Date: JUL 17 2017 Tooling: _____ Date: _____ Run Start ***NR1***
21 3-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
QC: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3537	E								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.78							
FLOW CNC Waterjet	1-Cut D3537-3 as per Dwg D3537								
	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.16							
Quality Control									

(11a) 02/17/08/09

(11a) 02/17/08/09

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Work Order ID 164273

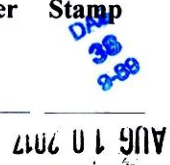
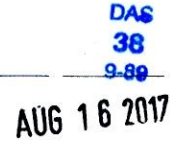
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.32				<u>16</u>			
130 *130* Brake NC Brake NC	Form as per dwg NC BRAKE Memo	0.15 0.53				<u>16</u>	<u>Ø</u>	AUG 15 2017	
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.32				<u>16</u>			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* autoweld 1 Automated Welding 1	Weld per dwg & QSI004 4.5 Large Fab Memo ***SEE NOTE 8 FOR SURFACE BUILDUP*** 1- WELD AS PER DWG AND QSI004 4.5 FOR AUTOMATED WELDING USE 8259 HARDCOAT BATCH: <u>1132716</u>	0.00 0.00				<u>10</u>	<u>Q.L</u>	<u>17-08-22</u>	
160 *160* QC Quality Control	QC10- Inspect visual per QSI004- ground welds Memo	0.00 0.00				<u>16</u>			<u>DAG</u> <u>38</u> <u>8-89</u> AUG 23 2017
170 *170* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.32				<u>16</u>			<u>DAG</u> <u>38</u> <u>8-89</u> AUG 23 2017

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WORK ORDER NON-CONFORMANCE / UPDATE



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Identify as per dwg & Stock Location:	0.00							
200 Packaging Packaging	Memo LOCATION : FP001	0.16				<u>16</u>	<u>AUG 25 2017</u>	<u>68-1</u> <u>9</u> <u>DAS</u>	
210	QC21- Final Inspection - Work Order Release	0.00							
210 QC Quality Control	Memo	1.60							<u>17/9/15</u> 

DAS
21
9-88

AUG 25 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Picklist Print

Monday, July 17, 2017 8:54:44 AM

Page 1

Work Order ID: 164273

164273

Parent Item: D3537-3

D3537-3

Parent Item Name: Wearpad

Start Date: 8/25/2017

Required Date: 9/6/2017

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:A New Issue 07-02-14 JLM
15.10.16 AUTOMATED PROCESS DD VERF:JLM

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased				100	sf	22.9920	0.149	2.509474			

M304S16GA

07/17/08/09

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT010

22.992

m136896

0.3

m137110

0.132

m137175

1.1

m137341

2.62

m137400

12.1

m137844

6.74

138109

2.3

DQA: _____ Date: _____

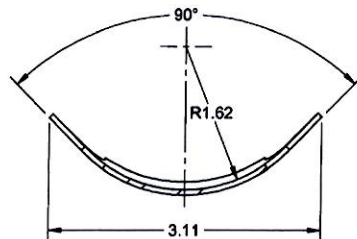


WORK ORDER NON-CONFORMANCE / UPDATE

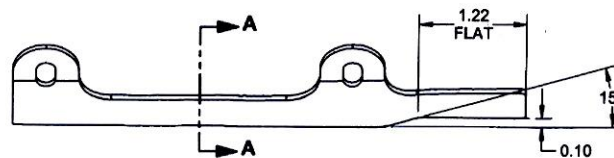
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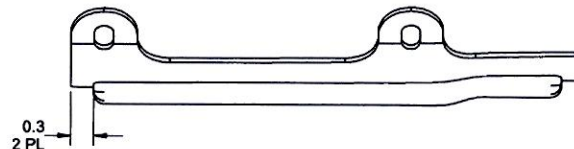
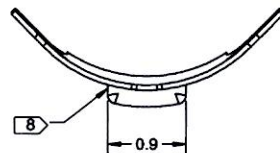
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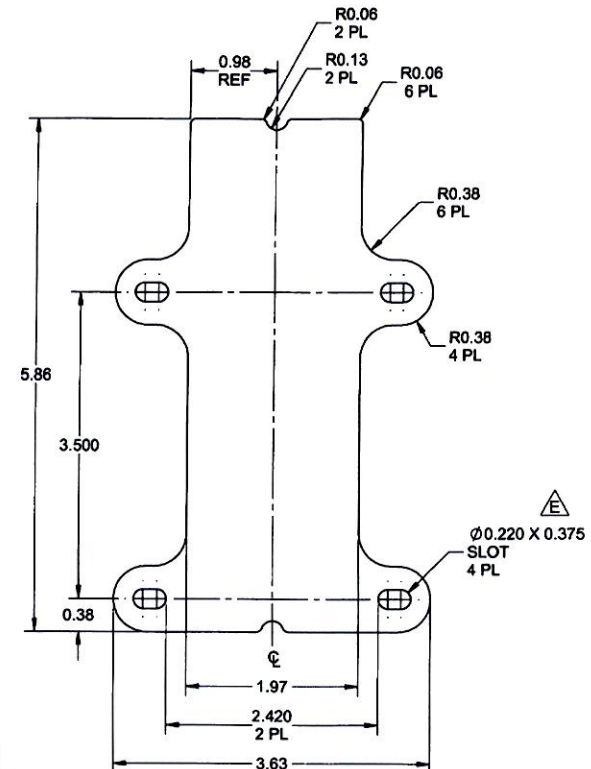
SECTION A-A



D3537-3 WEARPAD
(BENDING DETAIL)
(MAKE FROM D3537-3F)



D3537-3 WEARPAD
(WELDMENT)



D3537-3F WEARPAD
(FLAT PATTERN)

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.50 lbs
- 8) BUILDUP HARD SURFACING 0.17 - 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 - 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)

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APPROVED

DESIGN	CB
DRAWN	AJS
CHECKED	AP
MFG. APPR.	JLM
APPROVED	WM
DE APPR.	DS
DATE	15.09.28

DART AEROSPACE USA, INC. EUGENE, OR	
DRAWING NO. D3537	REV. E SHEET 2 OF 5
TITLE WEARPAD	SCALE NTS
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